

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015657**Date Inspected:** 17-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Subassembly, Bay 04, 13BE, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3092(PL3188A)-001-002 (Y-Location 50); located on subassembly, Bay 04, 13BE. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR. The attached photographs provide additional detail.

Subassembly, Bay 04, 13AE, Deck Panel U-ribs.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel "Chun Guang" carrying out Magnetic Particle Testing (MT) on Deck panel to U-rib welds. Deck Panel identified as DP3079-001. The attached photographs provide additional detail.

Subassembly, Bay 04, 13BE, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3086-001-112, 113, 115; located on subassembly, Bay 04, 13BE. Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

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Y-Locations of repairs were;

W112 – 50mm.

W113 – 50mm.

W115 – 550mm.

Subassembly, Bay 04, 13BE, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3086-001-003, 112, 114; located on subassembly, Bay 04, 13BE. Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Y-Locations of repairs were;

W003 – 50mm.

W112 – 4650mm.

W114 – 4650mm.

Subassembly, Bay 04, 13BE, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3089-001-004, 006, 010; located on subassembly, Bay 04, 13BE. Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Y-Locations of repairs were;

W004 – 4050mm, 4550mm.

W006 – 4550mm.

W010 – 2450mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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